








Work Order ID 66285

Thursday, February 10, 2011 3:05:05 PM



Page 1

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	2/9/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/23/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>11-02-10</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B

100	Weld per dwg A/R S.S. rod Batch: <u>M114649</u>	0.00							
	Large Fab								
Large Fab									
Large Fab									
	Memo	0.00							
	1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg D3914 ***inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***make sure to place mesh correctly on lid, check with label plate before tacking mesh***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control									
	Memo	0.00							

11/02/16 (1x)

11-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 2/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

Sublet



QC

Memo

0.00

Quality Control

(Handwritten mark)

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M1102588

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: *8:50*

Oven Temperature: *320°*

Finish Time: *9:20*

1 BK 11-02-18

140

Wing Walk as per dwg QSI005 4.4 Batch *X11164002*

0.00



HandFinish

Memo

0.00

Hand Finishing

1 Mask data plate and apply wing walk on outside surface of mesh as per dwg

2 Install placard and label as per dwg

1 11/02/18

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Setup Start



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Stop



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Required Date: 2/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 10/02/22 @

160

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

w/o 66380

0.00

Packaging

EP 11/02/22 @

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/02/22 JD**11-02-22 @*

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[illegible]

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Required Qty: 1.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581  Mounting Bracket		Manufactured	No			100	Each	32.0000	2	2		11/02/16	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				32					
					64112			9			(2x)		
					65950			23					
D2728-3  Dart Logo label		Manufactured	No			140	Each	0.0000	1	1		11/02/16	
								M115050		(x1)			
✓ D3914-1  Rib		Manufactured	No			100	Each	2.0000	2	2		11/02/16	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					65316			2			(2)		
✓ D3914-7  Rib		Manufactured	No			100	Each	2.0000	2	2		11/02/16	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					65404			2			(2)		

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 66285



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 2/9/2011

Required Date: 2/23/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-041 Manufactured No

100

Each

1.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



B66287 (1x) 11/02/16

Location

Loc Qty

Loc Code

WA

1

65426

1

✓ D4035-043 Manufactured No

100

Each

1.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



B66288 (1x) 11/02/16

Location

Loc Qty

Loc Code

WA

1

65427

1

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Shop Packet Print

Page 3

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALIS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 1 OF 4
MFG. APPR.	WJ	TITLE	SCALE
APPROVED	WJ	LONG BASKET LID ASSY (350)	NTS
DE APPR.	WJ	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED BY THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.08.05		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

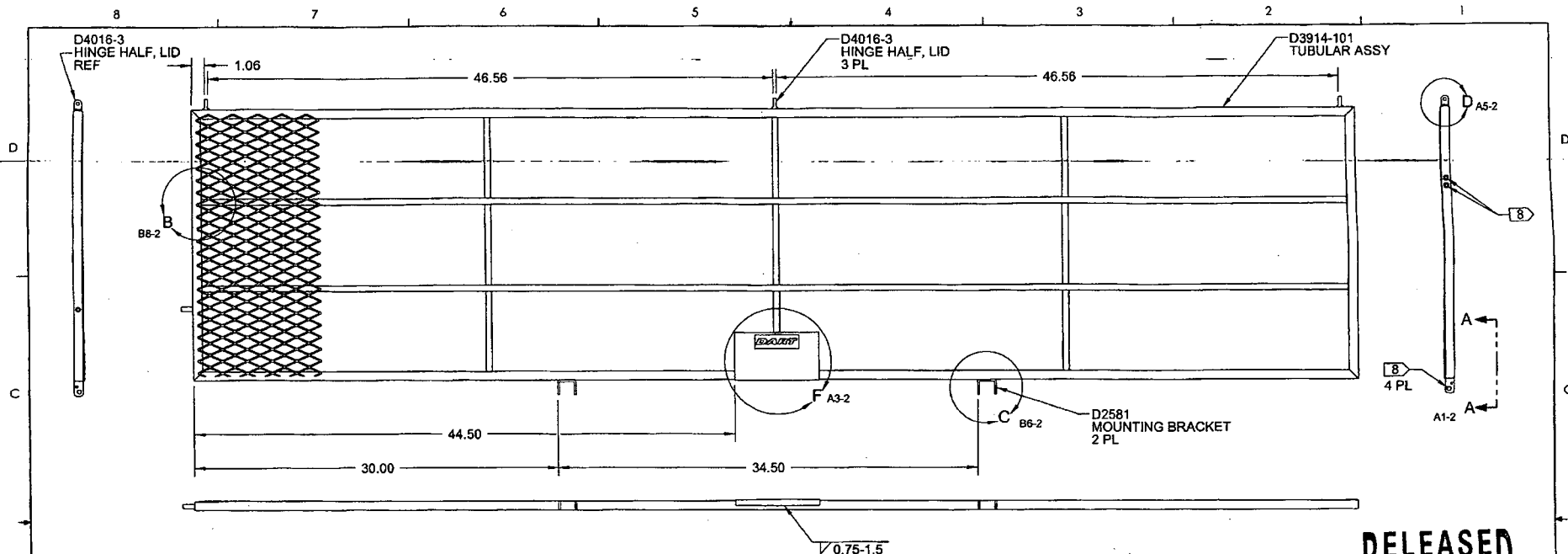
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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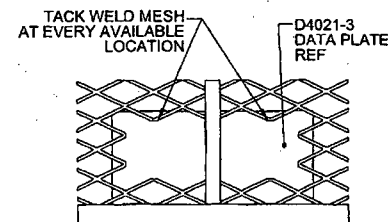
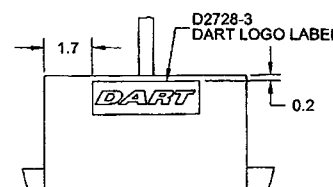
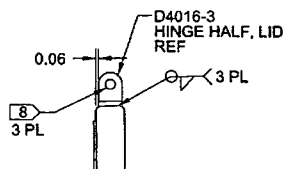
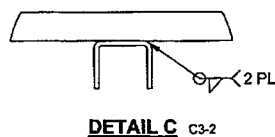
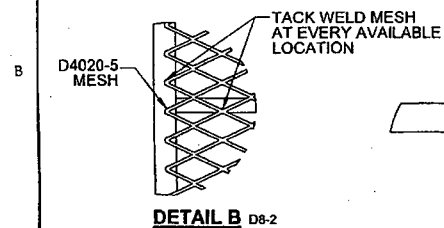
NOTE: Date & initial all entries

#6685



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 up



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3914	REV. B
CHECKED	SC	SHEET 2 OF 4	
MFG. APPR.	WJ	TITLE	SCALE
APPROVED	WJ	LONG BASKET LID ASSY (350)	
DE APPR.	WJ	NTS	
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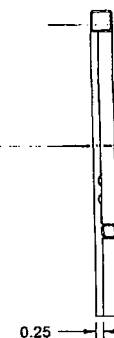
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

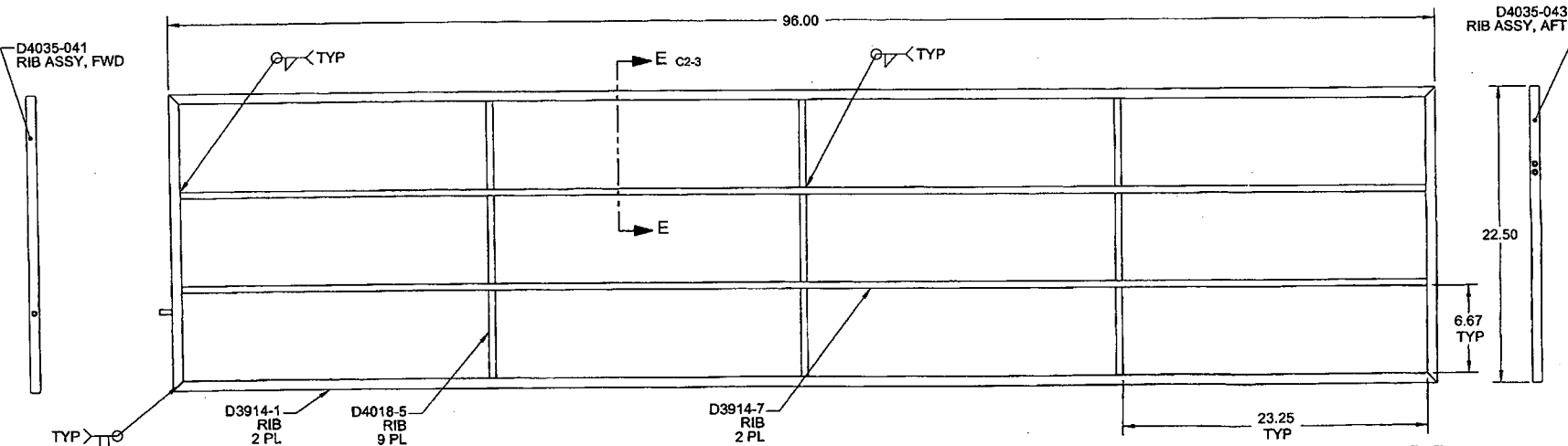
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NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10.08.12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3914	SHEET 3 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	LONG BASKET LID ASSY (350)	NTS
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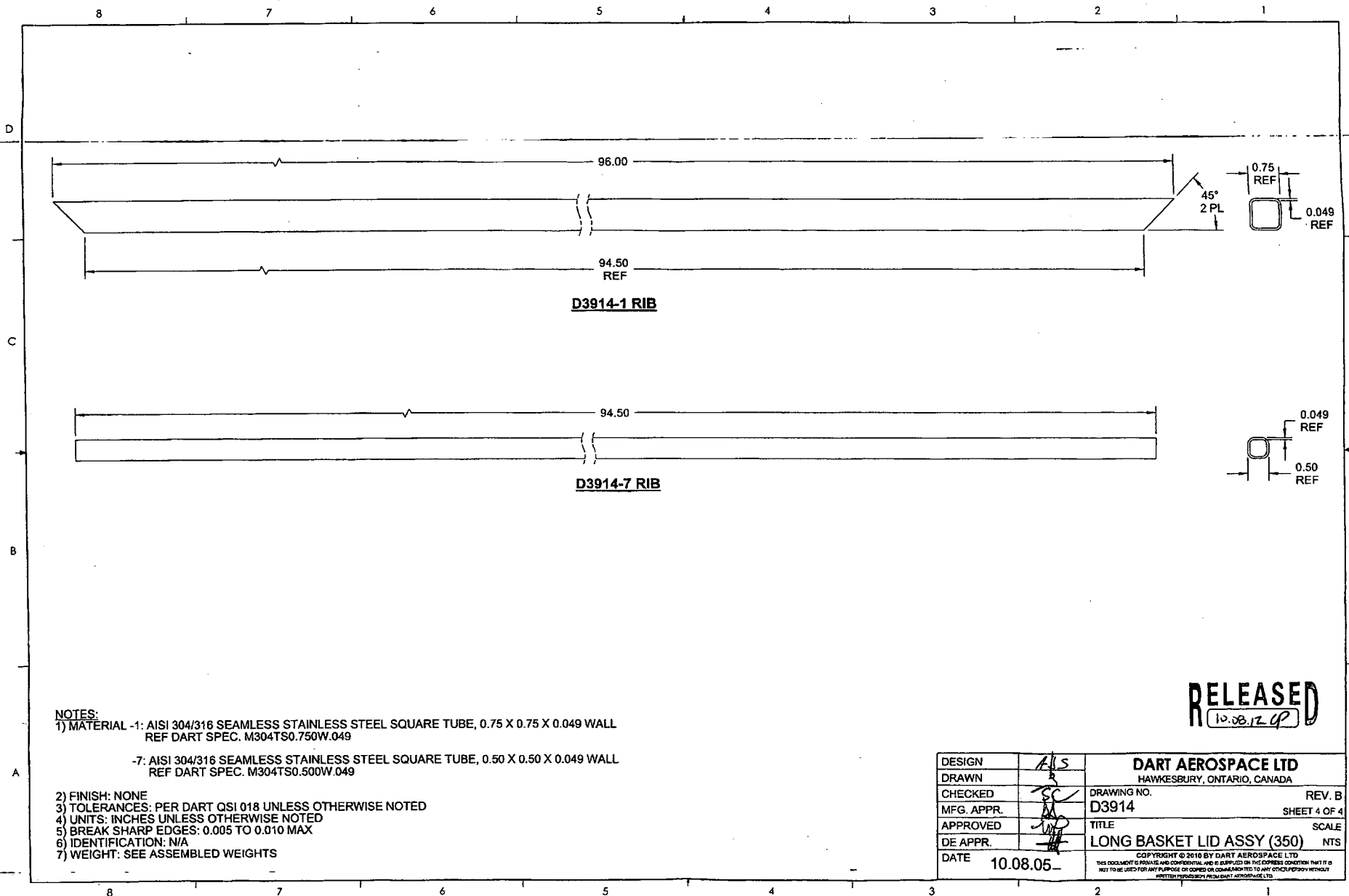
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NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 4 OF 4
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